

**\*88946\***

*Saturday, August 11, 2012 12:38:20 PM*

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*8\***

**\*8\***

**Reference:**

Run Start \*NR1\*

Date: 12/08/13

Date:

Stop \*NR2\*

Date:

**SPC (Y/N):**

Date:

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3642	Rev B

0.00

**\*100\***

## FLOW WATER JET

## Waterjet

## Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3642    Dwg Rev: *B*    Prog Rev: *B*    2-

7674 050

Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

## Memo

0.00

## Quality Control

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

**Work Order ID 88946****\*88946\***

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Saturday, August 11, 2012 12:38:20 PM

Item ID: D3642-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 8/13/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

8 76 12-8-22

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/8/2254

150

Identify as per dwg &amp; Stock Location

244

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

8 2 12/08/22

**Work Order ID 88946****\*88946\***

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Saturday, August 11, 2012 12:38:20 PM

Item ID: D3642-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Doubler  
Start Date: 8/13/2012      Start Qty: 8.00      **\*8\***      Cust Item ID:  
Required Date: 8/24/2012      Req'd Qty: 8.00      **\*8\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 12 1081 23

MF 12-08-23

# Picklist Print

Saturday, August 11, 2012 12:38:19 PM

Page 1

Work Order ID: 88946

Parent Item: D3642-1

Start Date: 8/13/2012

Required Date: 8/24/2012

Parent Item Name: Doubler

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

235.7484

0.1664

~~1.4012632~~

1.5

Jm 12-8-13

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

235.7484204

117684

22.8

121216

87.4484204

121889

125.5

121889

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions  <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	88946
<b>Description:</b> Doubler		<b>Part Number:</b>	D3642-1
<b>Inspection Dwg:</b> D3642 <b>Rev:</b> B		<b>Page 1 of 1</b>	

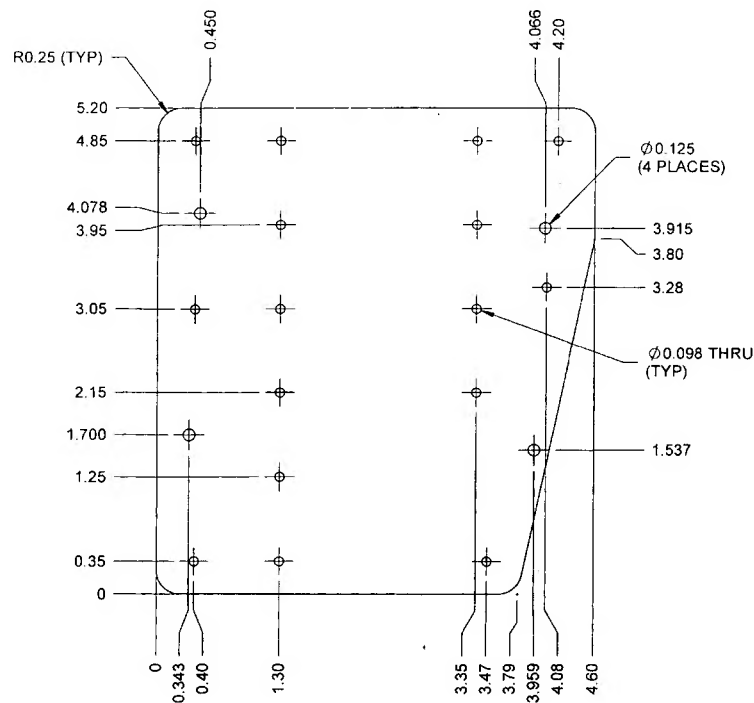
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	0.127"	-		✓	mm01
Ø0.098	+0.004/-0.001	0.099"	-		✓	
0.35	+/-0.030	0.354"	-		✓	
1.25	+/-0.030	1.255"	-		✓	
1.700	+/-0.010	1.703"	-		✓	
2.15	+/-0.030	2.155"	-		✓	
3.05	+/-0.030	3.052"	-		✓	
3.95	+/-0.030	3.953"	-		✓	
4.078	+/-0.010	4.079"	-		✓	
4.85	+/-0.030	4.851"	-		✓	
5.20	+/-0.030	5.202"	-		✓	
0.343	+/-0.010	0.346"	-		✓	
0.40	+/-0.030	0.399"	-		✓	
1.30	+/-0.030	1.301"	-		✓	
3.35	+/-0.030	3.354"	-		✓	
3.47	+/-0.030	3.471"	-		✓	
3.79	+/-0.030	3.790"	-		✓	
3.959	+/-0.010	3.961"	-		✓	
4.08	+/-0.030	4.089"	-		✓	
4.60	+/-0.030	4.602"	-		✓	
1.537	+/-0.010	1.535"	-		✓	
3.28	+/-0.030	3.275"	-		✓	
3.80	+/-0.030	3.80"	-		✓	
3.915	+/-0.010	3.916"	-		✓	
0.450	+/-0.010	0.455"	-		✓	
4.066	+/-0.010	4.065"	-		✓	
4.20	+/-0.030	4.202"	-		✓	

<b>Measured by:</b>	JM	<b>Audited by:</b>	DAS	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12-8-18	<b>Date:</b>	17/06/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	



**D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 88946 MLC

12/08/13

RELEASED  
27.11.14

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LC		
CHECKED	AL		
MFG. APPR.	EG		
APPROVED	#		
DE APPR.			
DATE	07.10.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3642	REV. B SHEET 1 OF 1
TITLE DOUBLER	SCALE 4:5
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